

# Work Order ID 124955

Tuesday, September 30, 2014 10:33:50 AM

**\*124955\***

Page 1

Item ID: D3825-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Rib Assembly (Basket End, Lid)  
Start Date: 9/30/2014 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 9/30/2014 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: MW Date: 10-09-30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3825    | C            |

100

0.00

**\*100\***

Large Fab

Large Fab

Large Fab

## Memo

1- cut D3825-3 rib as per dwg D3825

2- drill hole (3/16") in D3825-3 using DT9822 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-1 spacer & D4021-9 bushing as per dwg D3825

A/R S.S. Rod Batch: B125054

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

6X

OK 10-9-30

6X CC 14-10-4



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**\*124955\***

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Item ID: D3825-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Rib Assembly (Basket End, Lid)

Stop **\*NS2\***

Start Date: 9/30/2014 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 9/30/2014 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

14/11/6 JG  
ME  
14-11-06

# Picklist Print

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Page 1

Work Order ID: 124955

**\*124955\***

Parent Item: D3825-043

**\*D3825-043\***

Parent Item Name: Rib Assembly (Basket End, Lid)

Start Date: 9/30/2014

Required Date: 9/30/2014

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.07.24 AS PER REV.B DD VERF:EC IPP  
REV:B 12.08.08 AS PER DWG REV.C DD VERF:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2327-1                         |                        | Manufactured  | No          |                     |                  | 100             | Each               | 33.0000        | 1           | 6            |               |                |        |

**\*D2327-1\***

Spacer Bushing

\*\*

CC 14-10-31

Location

Loc Qty

Loc Code

WA004

33

107000

19

107115

14

D4021-9

Manufactured No

100

Each

266.0000

2

12

**\*D4021-9\***

Bushing

\*\*

CC 14-10-31

Location

Loc Qty

Loc Code

WA004

266

B116663

107634

2

116010

60

116663

64

117495

1

120334

40

121536

20

121805

21

122601

20

123427

38

12x

# Picklist Print

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Work Order ID: 124955

**\*124955\***

Parent Item: D3825-043

**\*D3825-043\***

Parent Item Name: Rib Assembly (Basket End, Lid)

Start Date: 9/30/2014

Required Date: 9/30/2014

Start Qty: 6.00

Required Qty: 6.00

M304TS0.750W.065

Purchased

No

100 f

1,561.415 2.125 14

**\*M304TS0 750W 065\***

**\*\***

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

WA004

125513

1561.415

493.015

m126538

362

m126922

106.4

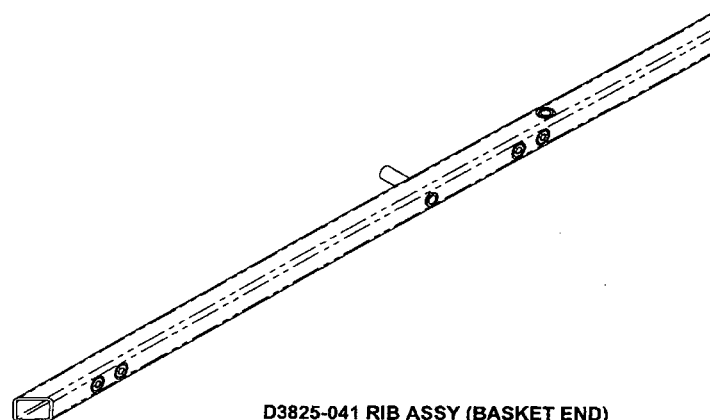
m128495

600

14

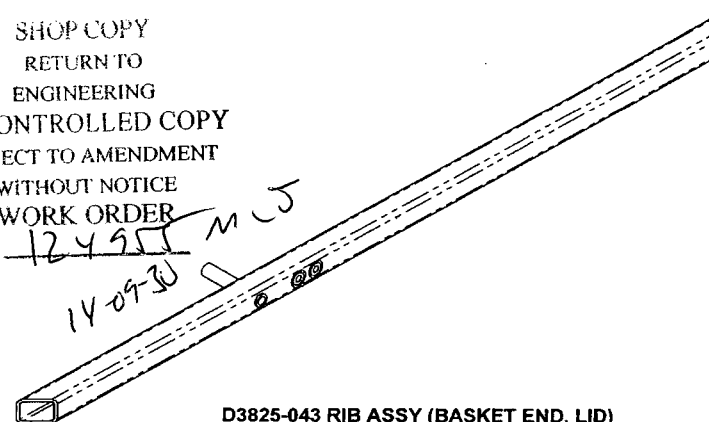
OL 14-9-30

| ITEM | QTY<br>-041 | QTY<br>-043 | P/N       | DESCRIPTION                    |
|------|-------------|-------------|-----------|--------------------------------|
|      | X           |             | D3825-041 | RIB ASSEMBLY (BASKET END)      |
|      |             | X           | D3825-043 | RIB ASSEMBLY (BASKET END, LID) |
| 1    |             | 1           | D2327-1   | SPACER BUSHING                 |
| 2    | 1           |             | D2327-3   | SPACER BUSHING                 |
| 3    | 1           |             | D3759-1   | BUSHING                        |
| 4    | 1           |             | D3825-1   | RIB                            |
| 5    |             | 1           | D3825-3   | RIB                            |
| 6    | 4           | 2           | D4021-9   | BUSHING                        |



**D3825-041 RIB ASSY (BASKET END)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 124955 MJS  
14-09-30



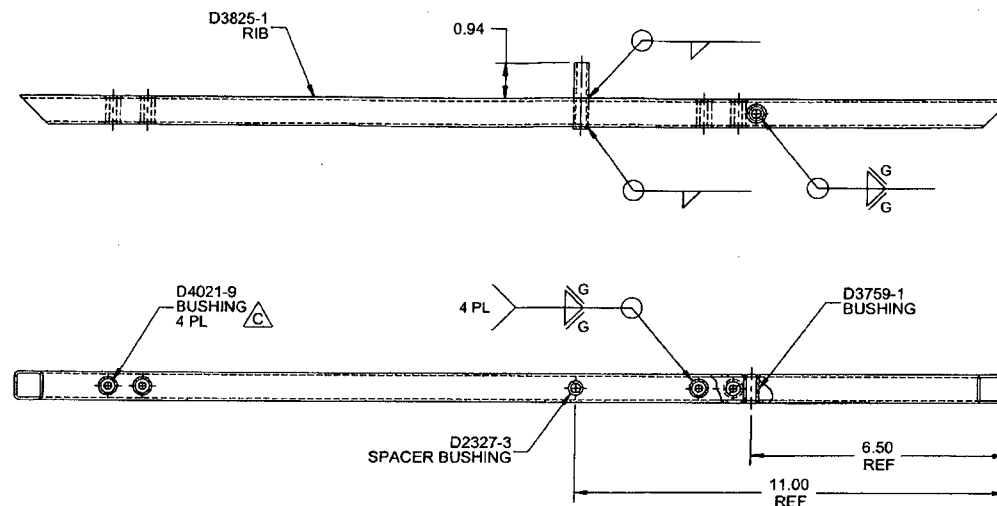
**D3825-043 RIB ASSY (BASKET END, LID)**

RELEASED  
2012-03-03  
WJP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3825-041 = 1.27 lbs; D3825-043 = 1.23 lbs
- 8) WELDING: PER DART QSI 004

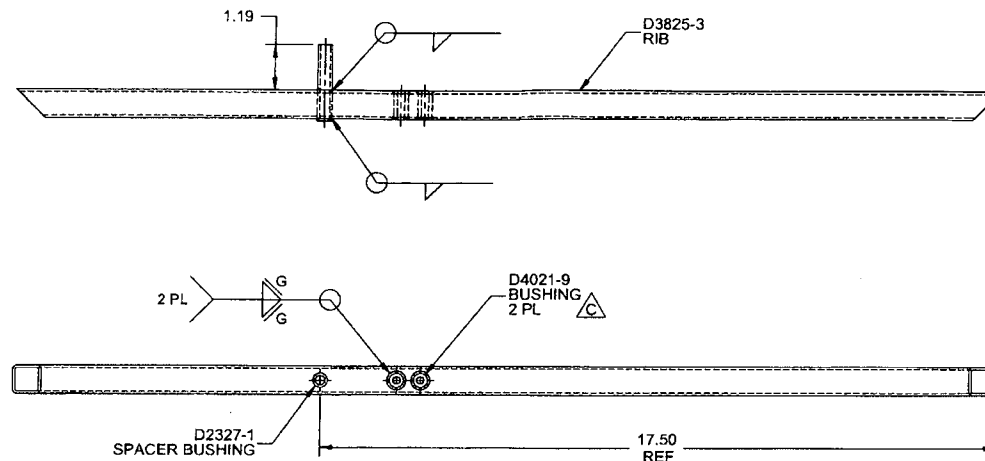
| C   | QTY(4) D4021-9 ON -041 AND QTY(2) D4021-9 ON -043 WERE D3759-1. CORRECTED DIM (Z4 B3-4) WAS 14.875. REASON FOR CHG: ANS SIZE BOLTS REQ'D IN THOSE LOCATIONS. | MB | 12.07.18 |
|---|--|----|----------|
| B   | QTY(5) FOR D3759-1 WAS QTY(1): AFFECTS D3825-041/1 (ZNS D3-1, C4-2, C3-2, D4-4, C6-4, C4-4, C3-4). ADDED D3825-043/3. REASON: PAR10-50.                      | MB | 12.05.11 |
| A   | NEW ISSUE  | MB | 08.08.23 |
| REV.  | DESCRIPTION  | BY | DATE     |
| DESIGN  | 1/1  |    |          |
| DRAWN   | 1/1  |    |          |
| CHECKED   | AP   |    |          |
| MFG. APPR.  | 1/1  |    |          |
| APPROVED  | 1/1  |    |          |
| DE APPR.  | 1/1  |    |          |
| DATE  | 12.07.18   |    |          |
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D3825</b> REV. C<br>SHEET 1 OF 4<br>TITLE <b>RIB ASSY (BASKET END)</b> SCALE NTS<br><small>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |  |    |          |



**D3825-041 RIB ASSY (BASKET END)**

**RELEASED**  
2012-08-03  
JMP

|            |          |  |        |
|------------|----------|--|--------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>  |        |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |        |
| CHECKED    | AL       | DRAWING NO. D3825  | REV. C |
| MFG. APPR. |          | SHEET 2 OF 4   |        |
| APPROVED   |          | SCALE  |        |
| DE APPR.   |          | RIB ASSY (BASKET END) NTS  |        |
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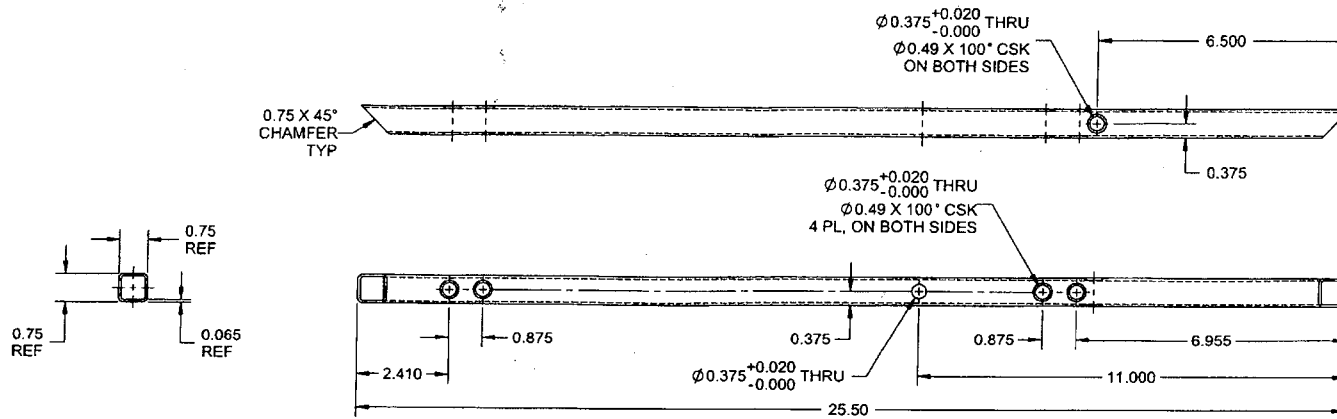


**D3825-043 RIB ASSY (BASKET END, LID)**

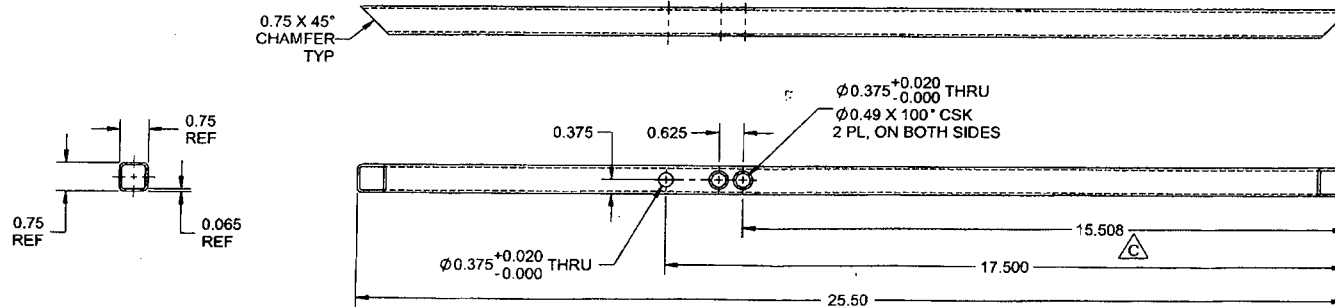
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2012-08-03

|            |          |  |              |
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| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |          | DRAWING NO.  | REV. C       |
| MFG. APPR. |          | D3825  | SHEET 3 OF 4 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | RIB ASSY (BASKET END)  | NTS          |
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**D3825-1 RIB**



**D3825-3 RIB**

RELEASED  
2012-08-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs

|  |          |  |              |
|--|----------|--|--------------|
| DESIGN   |          | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN  |          | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  |          | DRAWING NO.                            | REV. C       |
| MFG. APPR.   |          | <b>D3825</b>                           | SHEET 4 OF 4 |
| APPROVED   |          | TITLE                                  | SCALE        |
| DE APPR.   |          | <b>RIB ASSY (BASKET END)</b>           | NTS          |
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